

Work Order ID 140646

140646

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To ship Jan 15

Item ID: D205-770-011

Accept

N1900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Engine Mounts

Stop

NS2

Start Date: 1/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: SA Date: 20160112 Tooling: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D205-770	D

DAS
6
9-89

100 Document Control 0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D205-770-011 CHG006

DAS
28
9-89

JAN 14 2016

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

JAN 13 2016

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.00

Quality Control

VERIFY ASSEMBLY OF TRIPOD

DAS
28
9-89

JAN 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : ☐							

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140646

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Item ID: D205-770-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: Replacement Engine Mounts

Start Date: 1/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				1	DAS 28 9-89	JAN 14 2016	
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-770-011 Location: FG028								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS JAN 14 2016

ME
16-1-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐
Design ☐	☐	Operator ☐		☐	Set-up ☐	☐	Folio/Program ☐
Doc/Data ☐	☐	Offset/Setup ☐		☐	BOM/Route ☐	☐	Grain ☐
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks ☐	☐	Weld ☐
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave ☐	☐	Wrong Stock Pulled ☐
Material ☐	☐	Use for Testing ☐		☐	Cuffs ☐	☐	Out of Sequence ☐
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing ☐	☐	Off-set ☐
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat ☐	☐	Mislabeled ☐
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube ☐	☐	Fit/Function ☐
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter ☐	☐	Misaligned/off center ☐
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____			
Misidentified ☐	☐	Past Due ☐					

Picklist Print

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Work Order ID: 140646

140646

Parent Item: D205-770-011

D205-770-011

Parent Item Name: Replacement Engine Mounts

Start Date: 1/12/2016

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue ECN1165p 08-03-31 DD verified by:EC IPP REV:B
11.12.05 PER ECN11-676 DD VERF:EC IPP REV:C 13.01.24
PER ECN12-693 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3684-043 *D3684-043* Mount Assembly		Manufactured	No			110	Each	3.0000	1	1		DAS 6 9-89	DAS 27 9-89
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST232	137083			3					
								3					
D3684-045 *D3684-045* Inboard Leg Assembly		Manufactured	No			110	Each	2.0000	1	1		DAS 6 9-89	DAS 27 9-89
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST231a				2					
					101549			1					
					128408			1					
D3685-041 *D3685-041* Bipod Mount Assembly		Manufactured	No			110	Each	2.0000	1	1		DAS 6 9-89	DAS 27 9-89
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST231B				2					
					132947			2					
D3686-041 *D3686-041* Monopod Assembly		Manufactured	No			110	Each	1.0000	1	1		DAS 6 9-89	DAS 27 9-89
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST231a				1					
					112557			1					

JAN 13 2016

Picklist Print

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Work Order ID: 140646

Parent Item: D205-770-011

Parent Item Name: Replacement Engine Mounts

140646

D205-770-011

Start Date: 1/12/2016

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

HL32PB8-14

Purchased

No

110

Each

109.0000

2

2

DAS

6

9-89

DAS

27

9-89

HI 32PB8-14

Replacement Hi-Lok Pin

DAS
28
9-89

Location

Loc Qty

Loc Code

ST554

109

125436

2

m128179

7

m128454

100

HL86-8

Purchased

No

110

Each

120.0000

2

2

DAS

6

9-89

DAS

27

9-89

HI 86-8

Collar

DAS
28
9-89

Location

Loc Qty

Loc Code

st555

120

m127815

20

m131803

100

13-420

Purchased

No

110

Each

24.0000

1

1

DAS

6

9-89

DAS

27

9-89

13-420

Piloted Drill

DAS
28
9-89

Location

Loc Qty

Loc Code

ST562

24

124728

24

44-300

Purchased

No

110

Each

19.0000

1

1

DAS

6

9-89

DAS

27

9-89

44-300

Step Reamer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST562

19

124728

19

JAN 13 2016

REPLACEMENT ONLY

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-770-011 Kit.

DAS

28

9-89

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-770-011	14.6 lb	-3.5 in	-51.1 in-lb	190.0 in	2774 in-lb
Replacement Engine Mount Kit	6.62 kg	-0.09 m	-0.6 m-kg	4.83 m	31.97 m-kg

5. PARTS LIST

Qty -011	Part Number	Description
X	D205-770-011	REPLACEMENT ENGINE MOUNT KIT
1	D3684-043	MOUNT ASSEMBLY
1	D3684-045	INBOARD LEG ASSEMBLY
1	D3685-041	BIPOD MOUNT ASSEMBLY
1	D3686-041	MONOPOD ASSEMBLY
2	HL32PB8-14	HI-LOK PIN
2	HL86-8	HI-LOK COLLAR
1	13-420	PILOTED DRILL (0.2314 dia. w/ 0.2158 pilot)
1	44-300	STEP REAMER (0.2470 dia. w/ 0.2314 pilot)

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Revision: D

Date: 12.12.12